

Date: Wednesday, 12/7/2005 8:26:03 AM  
User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CROSSBOLT SPACER
<b>Job Number</b> : 25138	
<b>Estimate Number</b> : 10993	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2579
<b>This Issue</b> : 12/7/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2579 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : <u>See comment below</u>	<b>Due Date</b> : 1/13/2006 <b>Qty:</b> 500 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>See comment below</u>	
<b>Comment</b> : Est E 02.06.17 Now turned on Cobra NG	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
<b>Comment:</b> Qty.: 3.1354 f(s)/Unit Total: 1567.7025 f(s) 6061-T6 Tube .500 x.058W Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4) 0.500 Dia x 0.058 Wall Batch <del>178-178</del> <i>129.15</i> <i>M18740=57F 1/2</i> <i>M17267=82F 1/2</i> <i>M19405=30'</i> <i>Jul 05/12/12 500</i>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
<b>Comment:</b> HARDINGE CNC LATHE SMALL Machine as per Folio FA245 <i>Jul 05/12/12 500</i>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <i>Jul 05/12/12 500</i>		
4.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK <i>BG 06.01.07 500</i>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: _____ <i>Lu 06/01/09 500</i>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 12 Date: 24/11/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 25138

Part Number: D2579

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/01/11

506

DP 06/01/10

50

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	25138
<b>Description:</b> Cross Bolt Spacer	<b>Part Number:</b>	D2579
<b>Inspection Dwg:</b> D2579 <b>Rev:</b> D		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article

## Prototype

[illegible]

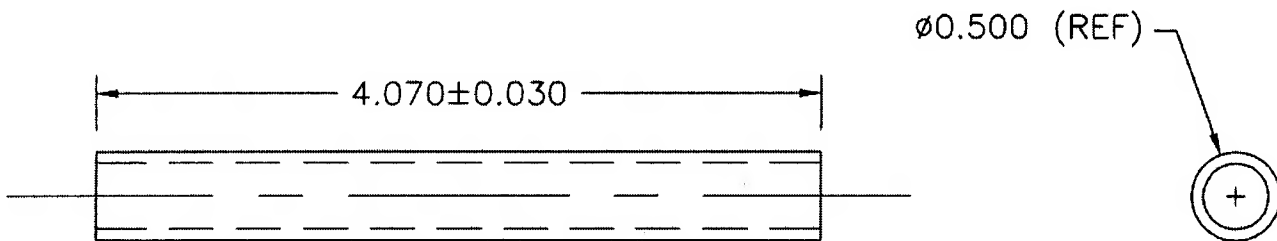
Measured by:	<i>gml</i>	Audited by:	<i>En</i>	Prototype Approval:	N/A
Date:	<i>05/12/12</i>	Date:	<i>05/12/12</i>	Date:	<i>N/A</i>

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RE	



DESIGN <del>DA</del>	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <del>DA</del>	APPROVED LE	DRAWING NO. D2579	REV. D SHEET 1 OF 1
DATE 99.05.19		TITLE CROSS BOLT SPACER	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	96.12.05	0.065 WALL WAS 0.035 WALL	
C	97.02.21	0.058 WALL WAS 0.065 WALL	
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)	

RELEASED  
99.05.20 DS



ENGINEER  
PRINTED COPY  
NOMENCL  
FORCE

ORDER  
25138

MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)  
0.500 DIA x 0.058 WALL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED